

Work Order ID 111293

111293

Page 1

January 10-14 10:26:12 AM

Item ID: 41232-200-004-001

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Reducer Tee Assembly

Start Date: 1/10/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/17/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

41232-200-004

Rev IR

100

0.00

100

CONVENTIONAL LATHE

Lathe Conv

Memo

0.00

Conventional Lathe

1-Turn AN815-4J as per Dwg 41232-200-0042-Debur as Required.

DR/D43
08
9-88
14-01-13

6 0

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Drill as per Dwg 41232-200-00
2-SPOT FACE 5/8" TO LOCATE FITTING FOR WELDING
3-Debur

DR/D43
08
9-88
14-01-13

6 0

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

DR/D43
08
9-88
14-01-13

6 0

Work Order ID 111293

January-10-14 10:26:12 AM

111293

Page 2

Item ID: 41232-200-004-001

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Reducer Tee Assembly

Stop

NS2

Start Date: 1/10/14 Start Qty: 8.00

g

Cust Item ID:

Required Date: 1/17/14 Req'd Qty: 8.00

g

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

6 0 14-01-13

140

Large Fab

0.00

140

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg 41232-200-004 A/R
Batch: M125054

SS Rod

6 0 14-1-20

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

1-WELD INSPECTION 2-Pressure test as per Dwg 41232-200-0043-
Passivate Finish.

6 14-01-21 DAS 9 9-89

Work Order ID 111293

January-10-14 10:26:12 AM

111293

Page 3

Item ID: 41232-200-004-001

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Reducer Tee Assembly

Start Date: 1/10/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/17/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location 81378

0.00

160

Packaging

Memo

0.00

Packaging

6x 14-1-21.

DAS
26
9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 14-01-22

(M) 14-01-21

Picklist Print

January-10-14 10:26:09 AM

Page 1

Work Order ID: 111293
 Parent Item: 41232-200-004-001
 Parent Item Name: Reducer Tee Assembly

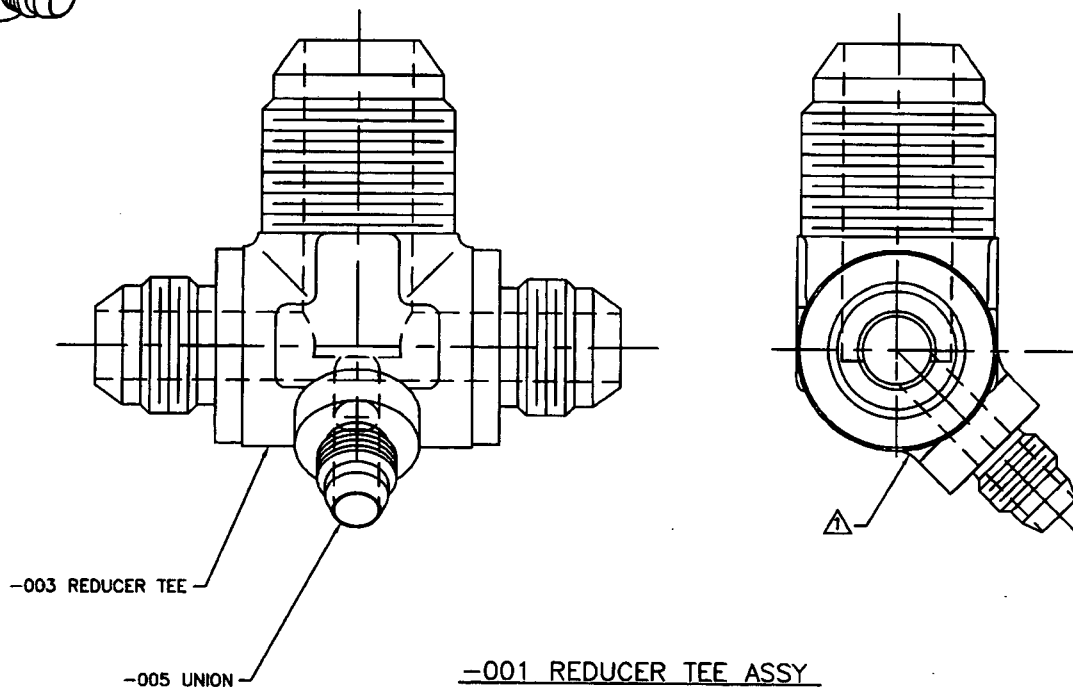
Start Date: 1/10/14 Required Date: 1/17/14
 Start Qty: 8.00 Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-03-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN815-4J union	AS5174J0404	Purchased	No			100	Each	4.0000	1	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST347		3			3				
				m127432		3							
				ST349		1							
				104253		1			1				
AS1035J080812 TEE		Purchased	No			100	Each	8.0000	1	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		8							
				m127875		8							

SR
 14-01-12
 M122809
 x
 4
 PUZZLES.

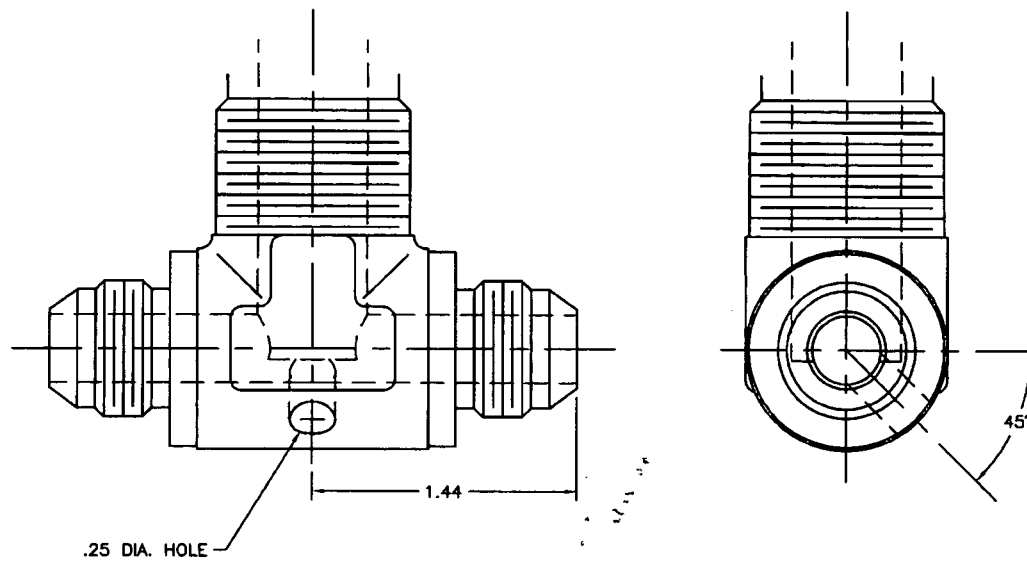
3
 1
 6



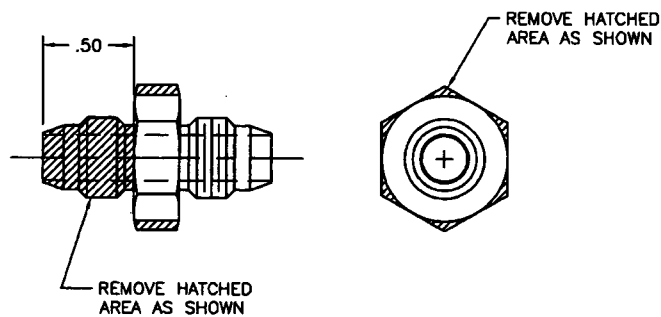
WELD IN ACCORDANCE WITH MIL-STD-2219 CLASS C.

NOTES:

				1	-005	UNION	MAKE FROM ANB15-4J UNION				
				1	-003	REDUCER TEE	MAKE FROM BELL P/N AS1035J080812 or 110-080-12C				
					-001	REDUCER TEE ASSY					
				-001	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC	ZONE	
NO. REQ'D PER ASSY					LIST OF MATERIAL						
PROPRIETARY RIGHTS NOTICE THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. DISCLOSURE, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSES IS FORBIDDEN WITHOUT WRITTEN PERMISSION FROM ERA AVIATION, INC. THE FOLLOWING DOES NOT APPLY TO VENDOR PARTS.						UNLESS OTHERWISE SPECIFIED X ± 1 XL ± .03 XXL ± .010 ANGLES ± .1°	DESIGN	D. NELSON	5/24/02	TITLE REDUCER TEE ASSY	
							CHECK	D. MURPHY	5/24/02		
							STRESS				
							PROJ. ENGR.				
				-001	2	41232-000-001		DWG. SIZE	C	SCALE	2:1
					NEXT ASSEMBLY		DWG. NO.		41232-200-004		REV.
							SHT		1 OF 2		IR
							FINISH		Era Aviation, Inc.		



-003 REDUCER TEE



-005 FITTING

PROPRIETARY RIGHTS NOTICE
 THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC.
 DISCLOSURE, REPRODUCTION, OR USE OF THESE DATA
 FOR ANY PURPOSE IS FORBIDDEN WITHOUT WRITTEN
 AUTHORIZATION FROM ERA AVIATION, INC. THE FORE-
 GOING DOES NOT APPLY TO VENDOR PARTS.

Era Aviation, Inc.

REDUCER TEE ASSY

REV
C

QWS. NO.
41232-200-004
SHT 2 OF 2

REV
IR

